

WHAT IS CLAIMED IS:

1. An optical data medium incorporating lenticular imaging, comprising:
  - a first translucent substrate having generally planar opposed top and bottom surfaces, said bottom surface for receiving an optical beam, and said top surface having a formed surface representing recorded data;
  - a reflective coating formed on said top surface of said first substrate;
  - a second translucent substrate having generally planar top and bottom surfaces, said bottom surface for bonding with a layer of bonding agent and said top surface having a plurality of lenticules; and
  - the layer of a bonding agent disposed between the reflective coating and the bottom surface of said second substrate, the bonding layer securing the first substrate to the second substrate.
2. The optical data medium of claim 1 wherein said second translucent substrate bottom surface incorporates a lenticular image.
3. The optical data medium of claim 2 wherein said lenticular image is formed onto said second substrate through lithographic printing.
4. The optical data medium of claim 2 wherein said lenticular image is formed onto said second substrate by one of: sheet-fed printing, web offset printing, flexographic printing, gravure printing, digital printing and electronic deposition printing.
5. The optical data medium of claim 4 wherein said digital printing comprises one of: dye sublimation printing, laser printing, electrostatic printing, ink jet printing and photographic emulsion.
6. The optical data medium of claim 1 wherein said first substrate is polycarbonate.
7. The optical data medium of claim 1 wherein said first substrate is manufactured of a plastic material of the group consisting of polyester, vinyl, polycarbonate, polyvinyl chloride, polyethylene terephthalate and amorphous polyethylene terephthalate.
8. The optical data medium of claim 1 wherein said second substrate is polycarbonate.
9. The optical data medium of claim 1 wherein said second substrate is manufactured of a plastic material of the group consisting of polyester, vinyl, polycarbonate, polyvinyl chloride, polyethylene terephthalate and amorphous polyethylene terephthalate.

10. The optical data medium of claim 1 wherein said plurality of lenticles each having a focal length.

11. The optical data medium of claim 10 wherein said second substrate incorporates a lenticular image at the focal length of said plurality of lenticles.

12. A method of fabricating an optical data medium incorporating lenticular imaging comprising the steps of:

- providing a data substrate having generally planar opposed top and bottom surfaces, said bottom surface for receiving an optical beam, and said top surface having a formed surface representing recorded data;

- providing a lenticular substrate having generally planar top and bottom surfaces, said top surface having a plurality of lenticles;

- positioning a bonding agent between the top surface of said data substrate and the bottom surface of said lenticular substrate; and

- bonding said data substrate to said lenticular substrate.

13. The method of claim 12 wherein said bonding step comprises a hot melt bonding process.

14. An optical data disc incorporating anti-counterfeiting imaging comprising:

- a first translucent substrate having generally planar opposed top and bottom surface, said bottom surfaces for receiving an optical beam and said top surface having a formed surface representing recorded data;

- a reflective coating formed on said top surface of said first substrate;

- a second translucent substrate having generally planar top and bottom surface, said bottom surface incorporating a lenticular image having anti-counterfeiting information, and said bottom surface for bonding with a bonding agent and said top surface having a plurality of lenticulars; and

- a layer of a bonding agent disposed between the reflective coating and the bottom surface of said second substrate, the bonding layer securing the first substrate to said second substrate.

15. The disc of Claim 14 wherein said lenticular image also includes a customer oriented image.

16. The disc of Claim 15 wherein the anti-counterfeiting information is viewable from a different angle compared to the customer oriented image through the top surface of the second translucent substrate.

17. The disc of Claim 14 wherein the anti-counterfeiting information is a series of images viewable through corresponding angles and the first and second translucent substrates have symmetrical and corresponding outer perimeters.

18. A method of fabricating an optical data disc incorporating anti-counterfeiting lenticular imaging comprising the steps of:

- providing a data substrate having generally planar opposed top and bottom surfaces, said bottom surface for receiving and optical beam and said top surface having a formed surface representing recorded data;

- providing a lenticular substrate having a generally planar top and bottom surfaces, said top surface having a plurality of lenticles and said bottom surface having lenticular anti-counterfeiting information;

- positioning a bonding agent between the top surface of the said data substrate and the bottom surface of said lenticular substrate; and

- bonding said data substrate to said lenticular substrate.

19. The method of Claim 18, wherein said bonding comprises a hot melt bonding process.

20. An optical data medium incorporating lenticular imaging, comprising:

- a first translucent substrate having generally planar opposed top and bottom surfaces, said bottom surface for receiving an optical beam, and said top surface having a formed reflective surface representing recorded data;

- a second translucent substrate having generally planar top and bottom surfaces, said bottom surface for bonding with a layer of bonding agent and said top surface having a plurality of lenticles; and

- the layer of a bonding agent disposed between the reflective surface of the first substrate and the bottom surface of said second substrate, the bonding layer securing the first substrate to the second substrate.

21. A display case for housing and displaying an optical data medium comprising:  
an optical data medium, releasably engageable with said case, said medium comprising:  
a first substrate having a plurality of lenticules on a viewing surface and a lenticular image printed on an opposed surface;  
a second substrate having optical data incorporated thereon; and  
wherein said first and second substrates are bonded to form a data medium having a lenticular image viewable thereon;  
a housing for enclosing said optical data medium, said housing including an aperture for displaying at least a portion of said optical data medium.